

Date: Monday, 2/19/2007 3:26:50 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER		
Job Number	: 30767		Part Number	: D30661		
Estimate Number	: 10383		Drawing Number	: D3066 REV.B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 2/19/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 2/28/2007 Qty: 60 Um: Each		
Previous Run	: 30558					
Written By						
Checked & Approved By						
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:B Now M6061-T6 06-06-23 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
Comment: Qty.: 0.0992 sf(s)/Unit Total : 5.9535 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080) Batch: <u>M101178</u> <u>M 07 02 23</u> <span style="margin-left: 100px;">(60)</span>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3066 Dwg Rev: <u>B</u> <u>M 07 02 23</u> <span style="margin-left: 100px;">(60)</span> Prog Rev: <u>B</u>		
2-Deburr if necessary <u>SAD 07/02/07</u> <span style="margin-left: 100px;">(60)</span>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>M 07 02 23</u> <span style="margin-left: 100px;">(60)</span>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>M 07 02 23</u> <span style="margin-left: 100px;">(60)</span>		
Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<u>KL</u> <span style="margin-left: 100px;">(60)</span>		
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
<u>DL/m-h</u> <u>02/03/02</u> <span style="margin-left: 100px;">(60)</span> <u>07/03/05</u> <span style="margin-left: 100px;">(60)</span>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/03/06  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 30767

Part Number: D30661

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

*B07/03/05 (60)*



7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*B07/03/05 (60) CW*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*D07/03/06*

Job Completion



*U 07/03/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>30767</b>
<b>Description:</b> Spacer	<b>Part Number:</b>	<b>D3066-1</b>
<b>Inspection Dwg:</b> D3066 <b>Rev:</b> B		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by: <u>m.m</u>	Audited by: <u></u>	Prototype Approval: N/A
Date: <u>07/02/23</u>	Date: <u>07/02/23</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	

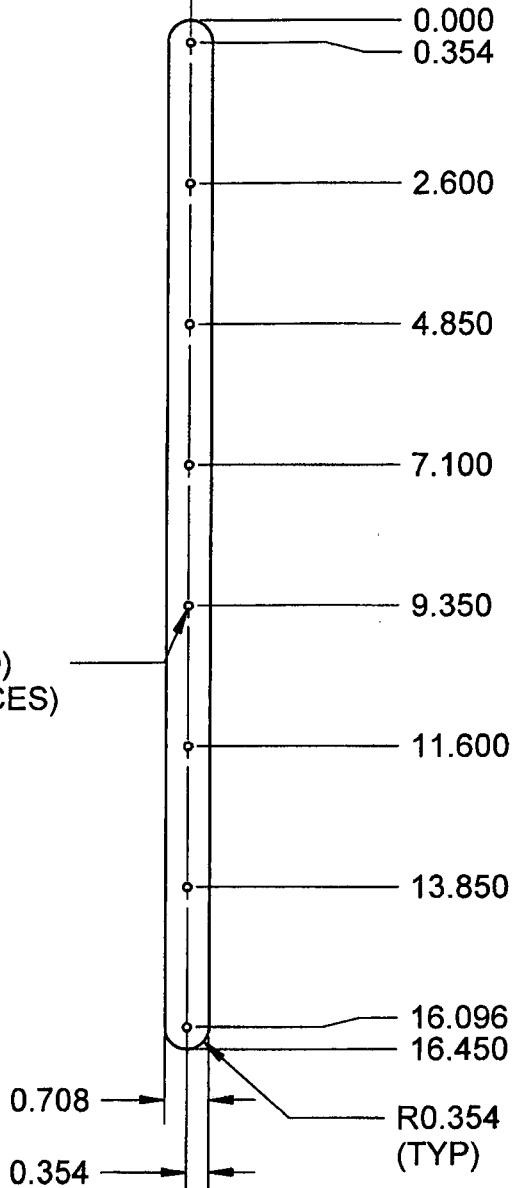
**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. <b>D3066</b>	REV. B SHEET 1 OF 1
DATE <b>06.05.29</b>	TITLE <b>SPACER</b>	SCALE 1:3	

A	02.09.11	NEW ISSUE
B	06.05.29	ADD 6061-T6 MATERIAL

**RELEASED***06.06.20 -ff*

$\phi 0.128$  (#30)  
(TYP 8 PLACES)

**D3066-1 SPACER**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK  
(REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *3076-1*

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